

Work Order ID 62239

Page 1

Wednesday, September 22, 2010 3:36:58 PM

Item ID: D3791-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 9/22/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-9-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3791	Rev A	

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

B 10-9-29

FLOW CNC Waterjet

364 .063

1-Cut as per Dwg D3791

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110 0.00



QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

B 10-9-29

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

S1010601

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

0.00

712

12

Memo

1-Deburr if necessary

2-Form on Brake as per Dwg D3791 using Jigs

S1010605

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S1010605

712

Memo

Ensure joggle as per dwg D3429

W/O:		WORK ORDER CHANGES					
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Item Name: Wearplate

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Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

150

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

0.00

0.00

0.00

S10/10/07

S10/10/07

S10/10/07

Large Fab

Large Fab

Large Fab

Memo

1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: 115850

160



QC10- Inspect visual per QSI004- ground welds

0.00

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LPL 10-10-06

160



QC

Quality Control



Quality Control



Quality Control



Quality Control



Quality Control



Quality Control



Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Item ID: D3791-1

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Item Name: Wearplate

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Start Date: 9/22/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



Powdercoat

Operation
Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

Set Up/
Run Hours

0.00

Tool ID
Bk 10-10-7.

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Powder Coating

Memo

START TIME: *10:10*
OVEN TEMPERATURE: *320°*
FINISH TIME: *10:40*

0.00

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

S colwotz

12

(412)

200



Packaging

Packaging

Identify as per dwg & Stock Location:

R-17

0.00

Bk 10-10-7

Memo

0.00

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 62239

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Wednesday, September 22, 2010 3:36:58 PM

Item ID: D3791-1

Accept



Setup

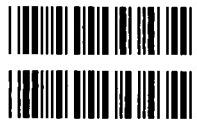
Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 9/22/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

210



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/10/07 JJ

MF
10-10-07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 22, 2010 3:37:02 PM

Page 1

Work Order ID: 62239



Parent Item: D3791-1



Parent Item Name: Wearplate

Start Date: 9/22/2010

Required Date: 9/22/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	160.8400	0.2917	3.684632		1B 10-9-29	

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT	146.7	
111323	0	
115688	146.7	115688
MAT20	14.14	
115440	14.14	

(12)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	102239
Description: Wearplate	Part Number:	D3791-1
Inspection Dwg: D3791	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	BS	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-29	Date:	10/10/01	Date:	N/A
Rev	Date	Change		Revised by	Approved
A	08.05.30	New Issue		KJ/DD	 

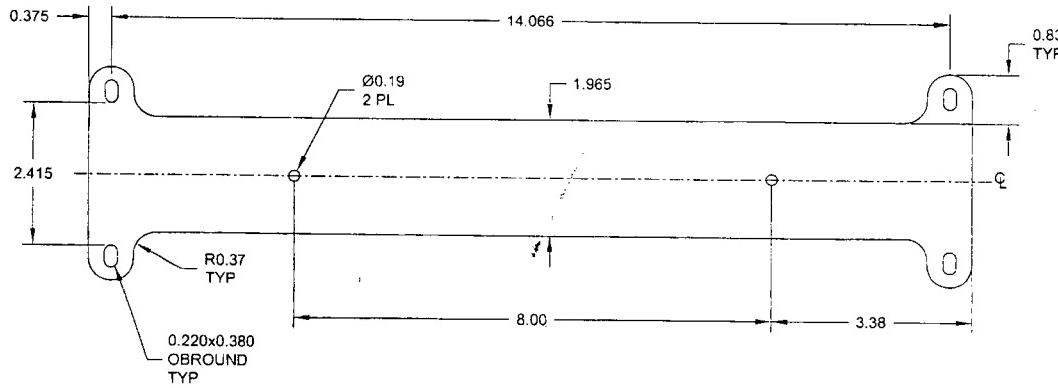
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

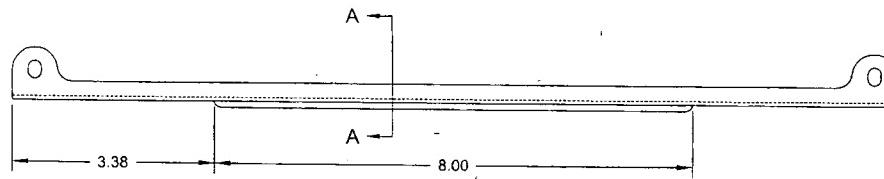
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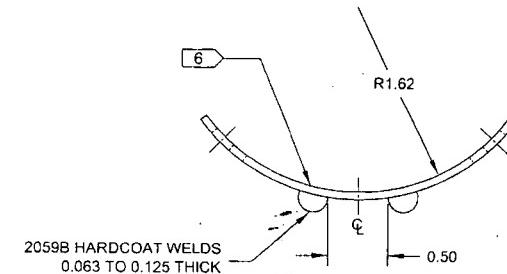
D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
(MAKE FROM D3791-1F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004



SECTION A-A
SCALE 2X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62239
B710-923

RELEASED
04-05-21 MB

A	NEW ISSUE	PH	08.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3791	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	08.05.13	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
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